

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:** Casey, William**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-026827**Date Inspected:** 06-Dec-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1730**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** As noted below.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Component**Summary of Items Observed:**

Quality Assurance Inspector (QA) William Clifford was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

West Line

This QA observed, at random intervals, ABF/JV qualified welder Salvador Sandoval #2202 performing Shielded Metal Arc Welding (SMAW) with 1/8" diameter E7018H4R electrode and implementing Caltrans approved Welding Procedure Specification (WPS) ABF-WPS-D15-1050A-CU. The joint being welded was a 20mm plate insert at the "A" deck to close the deck ventilation holes. This work was located at 14W-PP125.2-W3.7 and was performed in the flat position from the top of the "A" deck plate.

During welding, ABF Quality Control (QC) William Sherwood was noted monitoring the welding parameters. Welding parameters were recorded as (A=135).

Observation of QCUT:

QC Pat Swain performed Ultrasonic Testing (UT) of the completed weld at:
14W-PP126.2-W2.8 -no rejectable indications.

QC John Pagliero performed Ultrasonic Testing (UT) of the completed weld at:
14W-PP126.2-W3.2 -no rejectable indications.

Please see QCUT reports dated 12/06/11 for more information regarding these indications.

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Ultrasonic Testing

This QA performed Ultrasonic Testing (UT) on approximately 50% of the deck ventilation hole weld at 14W-PP126.7-W3.7. This weld was previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.

This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

This weld is a Seismic Performance Critical Member (SPCM) member.

This QA performed Ultrasonic Testing (UT) on approximately 500mm of 13W/14W-A2.2 weld from approximately (Y=650mm~1150mm).

These welds were previously accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3.

This QA observed no rejectable indications at the time of testing. This QA generated a TL-6027 UT report on this date. The completed work observed at this location appeared to be in compliance with the contract specifications.

This weld is a Seismic Performance Critical Member (SPCM) member.

This QA performed "information only" Ultrasonic Testing of approximately 600mm of the base material at the closed rib adjacent to the deck ventilation hole 14E-PP125.7-E3.2. This UT was performed to further investigate indications previously discovered during Quality Assurance percentage Ultrasonic Testing of the deck ventilation hole 14E-PP125.7-E3.2. Testing was performed using 70 degree and 45 degree shear wave testing angles. Indication appeared to be present from at depths ranging from approximately 14mm~20mm and appeared to have a length of approximately 200mm.

This testing was performed under the direct supervision of Quality Assurance Ultrasonic Level III Robert Mertz. No UT report has been filed at this time, testing is currently in process.

This QA verbally informed QA SPCM Lead, Daniel Reyes, of the issues noted in this report for compliance. For further details of issues of significance see QA SPCM Lead, Daniel Reyes, "Daily Inspection Report" (TL-6031) submitted for this date.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

No relevant conversations.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact SMR Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

Inspected By: Clifford, William

Quality Assurance Inspector

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Reviewed By: Levell,Bill

QA Reviewer